

Work Order ID 71653

Thursday, July 07, 2011 12:06:25 PM



Page 1

Item ID:	D3209-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	7/7/2011	Start Qty:	100	Cust Item ID:		
Required Date:	7/21/2011	Req'd Qty:	0.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>C2</u>	Date:	<u>11/07/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3209	Rev A								

100

 Bandsaw
 Jeaspa Bandsaw
 BAND SAW
 Memo
 Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)
 0.00
 FK- 11/07/05 10 0

110

 HAAS I
 HAAS CNC vertical machine #1
 Purchasing
 HAAS CNC VERTICAL MACHINING #1
 Memo
 Machine D3209-1 as per Folio FA345 and Dwg D3209-1 Identify as D3209-1
☐ Deburr and Tumble
 0.00
 Issue PO 14572
 Don's Precision
 machine per dwg D3209 Rev 1
 11-08-04

120

 QC
 Quality Control
 PKG
 QC2- Inspect parts off machine FAI/FAIB
 Memo
 Receive + Inspect for trust change
 Ensure C of C attached
 0.00
 11/11/07 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3209-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	7/7/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	7/21/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC Inspect parts - second check Memo	0.00 0.00				<u>40</u>			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>10</u>	<u>BL</u>	<u>11-11-8.</u>	
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo	0.00 0.00							

Note: Cover the hole for D3209-1 before powder coat. ☐ START TIME: 1:00 ☐ OVEN TEMPERATURE: 1-30
☐ FINISH TIME: 3200

M118489

10X M 11/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Thursday, July 07, 2011 12:06:25 PM

Item ID: D3209-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10. 8/11/08

161

QC3- Inspect Part Finish

0.00



Small Fab

Memo

0.00

Small Fab

press fit bushing as per dwg

8/11/10

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

x10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3209-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Identify as per dwg & Stock Location: STGA	0.00							
Packaging	Memo	0.00							11/11/14 (10)
Packaging									SP 11-11-14
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							11/11/15
Quality Control									

11/11/14
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, July 07, 2011 12:06:22 PM

Work Order ID: 71653

Parent Item: D3209-041

Parent Item Name: Bracket Assembly





Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A 04.06.09 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3209-3  Bushing		Manufactured	No			100	Each	34.0000	1	6			
<div> <div>Location</div> <div>ST041</div> <div>40930</div> </div> <div> <div>Loc Qty</div> <div>34</div> <div>34</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
M6061T6B1.500X01.25 0  6061-T6 Bar 1.50 x 1.25		Purchased	No			170	f	20.8278	0.175	1.105263			
<div> <div>Location</div> <div>MAT004</div> <div>110936</div> <div>118071</div> </div> <div> <div>Loc Qty</div> <div>20.8278</div> <div>8.8278</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

JS 11/11/10

10

F.K. 11/07/2010

1.625

D3209-1P

X 10

Cap 11/07/10 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

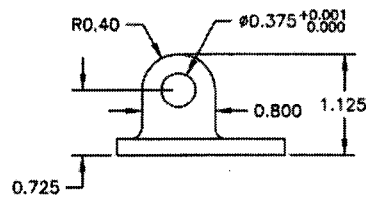
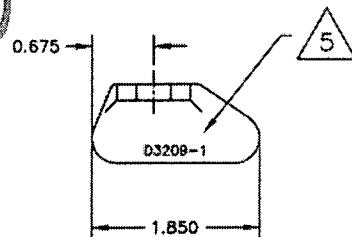
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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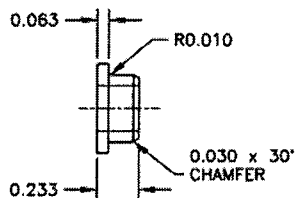
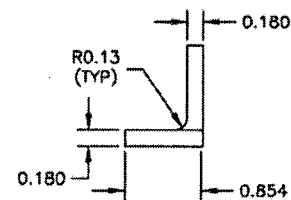
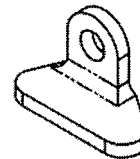
DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 [Signature]



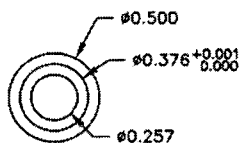
2

D3209-1 BRACKET



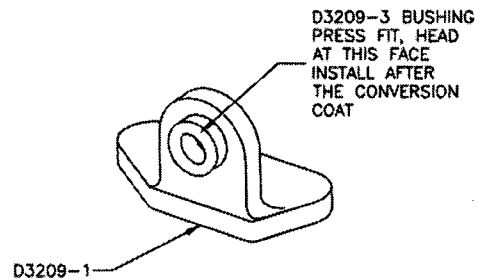
3

D3209-3 BUSHING
SCALE 1:2



4

D3209-041 ASSEMBLY



D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71653
CL11107107

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DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A-3H0
Tel: (613) 835-3097 Fax: (613) 835-3760
support@dans-precision-tools.com

PACKING SLIP

Ship To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7

Number: 10919

Date: November 04, 2011

Customer's Order: PO14572

Item#	Line#	Qty	Part #	Description	Status
1	9	10	D3209-1revA	Bracket	Complete
2	10	12	D3911-3revD	AFT Eyebolt Receiver, AFT Hardpoint, Basket	Complete

Number of Packages: ☐ Boxes _____
☐ Bags _____
☐ Bundles _____

Received by: _____ Date: _____

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 04-Nov-11
Purchase Order : PO14572
Packing Slip : 10919
Part Number : D3209-1revA
Quantity : 10

Suluog

Per: _____

For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE LTD.

P.O.: PO14572

W/O: _____

Part #: D3209-041 rev A

Assembly, Bracket

Qty: 10

1 of 1